

Monday, 1/16/2006 4:10:58 PM

User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SCUFF PLATE
Job Number :	25500	Part Number :	D206555003
Estimate Number :	11952	Drawing Number :	D206-555 REV B.
P.O. Number :		Project Number :	N/A
This Issue :	1/16/2006	Drawing Revision :	B
Prsht Rev. :	NC	Material :	
First Issue :	1/1	Due Date :	2/20/2006
Previous Run :		Qty:	10
Written By :		Um:	Each
Checked & Approved By :			
Comment :	est rev C 99.06.29 returned to electro polish DM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

E-mail or Ship DXF file to vendor
Laser cut flat pattern as per Dwg
Possible supplier: Ind. Laser
Material release note is required.

2.0

D206555003F

scuff plate flat



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
scuff plate flat

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Form parts on hydraulic press as per Dwg. D206-555
using DT 8316-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 25500

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Finish form on bench forming Jig DT 8317-3

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Electro polish

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Remove tooling tabs and deburr

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SCUFF PLATE

Job Number: 25500

Part Number: D206555003

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 290000 02

Mail To:
WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 11/22/2005 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/02aE;180Bend-OK

Your Order: P51013PC004

NAS Order: AE 0329272 02

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASMESA240/04, SA480/04, SA666/04
QSS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B40627	* 0679E9 A	.0240	48.0000	2,475 SHEET	120.00	2	65
B40628	* 0679E9 A	.0240	48.0000	2,485 SHEET	120.00	3	65

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
79E9	.057	18.152	.369	1.666	.319	.046	8.205	.029	.001	.326

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Tail Hard	Hard R45T
B40627	0679E9	F T	97.09	48.19	48.98	49.00	46.50
B40628	0679E9	F T	97.09	48.19	48.98	49.00	46.50

QC ENGINEER

ERIC HESS

11/22/2005